

Date: Thursday, 3/9/2006 8:32:11 AM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BLOWER INLET ADAPTER
Job Number :	26174		
Estimate Number :	12317		
P.O. Number :	N/A	Part Number :	D3473041
This Issue :	3/9/2006	S.O. No. :	N/A
Prsht Rev. :	NC	Drawing Number :	D3473 REV A
First Issue :	N/A	Project Number :	N/A
Previous Run :	N/A	Drawing Revision :	A
	Type :	Material :	N/A
	SMALL / MED FAB	Due Date :	3/30/2006
Written By :	<u>SEE COMMENT BELOW</u>		Qty: 1 Um: Each
Checked & Approved By :	<u>SEE ABOVE USER & DATE</u>		
Comment :	Est Rev: A New Issue 06-03-02 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D3473043	BLOWER INLET WELDMENT
-----	----------	-----------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3473-043	INLET ADAPTER	

26280
B 26274

AB 06 03 - 300

2.0	D34709	BOLT
-----	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3470-9	Bolt	

D26387

AB 06 03 - 300

3.0	AN960416	Washer
-----	----------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN960-416	Washer	

M19085

AB 06 03 - 300

4.0	AN3104	NUT
-----	--------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN310-4	Nut	

M19356

AB 06 03 - 300

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/9/2006 8:32:11 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLOWER INLET ADAPTER

Job Number: 26174

Part Number: D3473041

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

5.0	MS24665136	Cotter Pins
-----	------------	-------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	MS24665-136	Cotter Pin	<u>112421</u>

AB 06-03-30 ①

6.0	D3474041	Inlet valve shaft
-----	----------	-------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3474-041	Inlet valve shaft	<u>1026357</u>

AB 06-03-30 ①

7.0	MS35206217	Screw
-----	------------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	MS35206-217	Screw	<u>113883</u>

AB 06-03-30 ①

8.0	AN9604L	washer
-----	---------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	AN960-4L	Washer	<u>114606</u>

AB 06-03-30 ①

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/9/2006 8:32:11 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLOWER INLET ADAPTER

Job Number: 26174

Part Number: D3473041

Job Number:



Seq. #: Machine Or Operation: Description :

9.0 NAS679A04 NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	NAS679A04	Nut	M100546

AB 0603-30 ①

10.0 D34747 Valve seal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3474-7	Valve Seal	B26276

AB 0603-30 ①

11.0 D34745 Valve flat pattern



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3474-5	Valve Plate	B26123

AB 0603-30 ①

12.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3473

Ensure that Valve Assembly Opens & Closes Smoothly

AB 0603-30 ①

13.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

14.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

AB 0603-30 ①

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 02/03/03
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/9/2006 8:32:11 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLOWER INLET ADAPTER

Job Number: 26174

Part Number: D3473041

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

[Handwritten signature] 06/03/31 (21)

Job Completion



U 06-03-30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

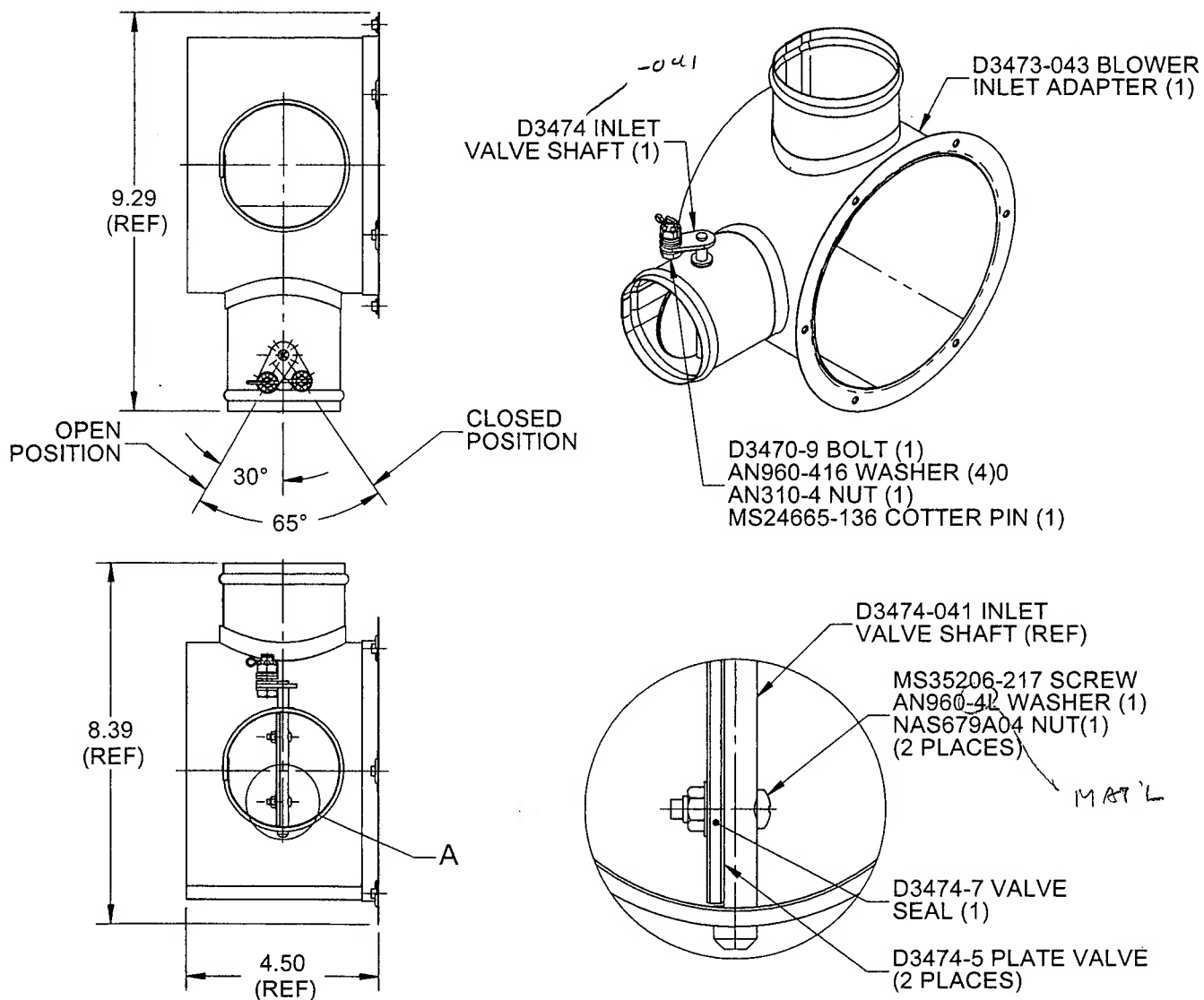
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PRELIMINARY ISSUE

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CHECKED	APPROVED	DRAWING NO. D3473	REV. A SHEET 1 OF 7
DATE 06.02.07		TITLE BLOWER INLET ADAPTER	SCALE 1:4
A	06.02.07	NEW ISSUE	



PARTS LIST

DETAIL A
SCALE 1:1

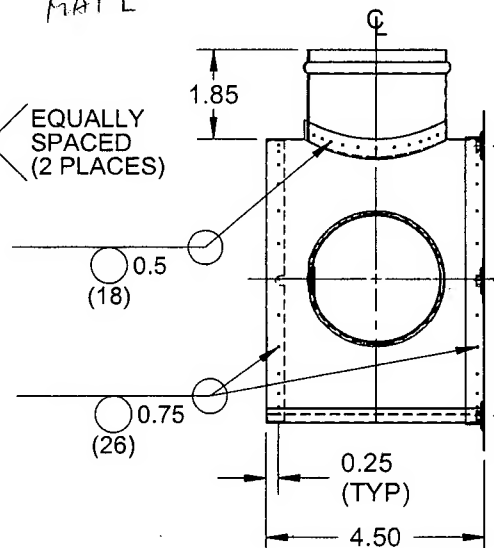
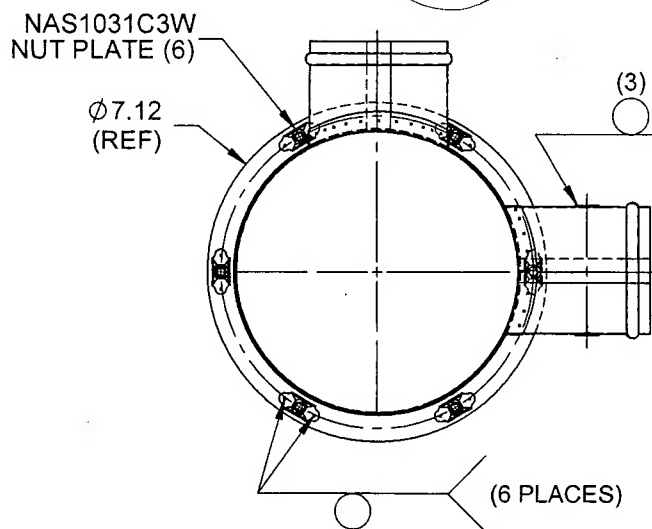
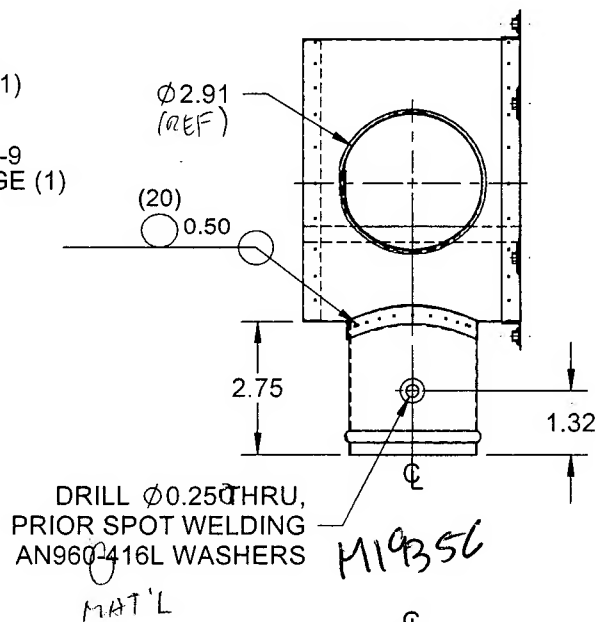
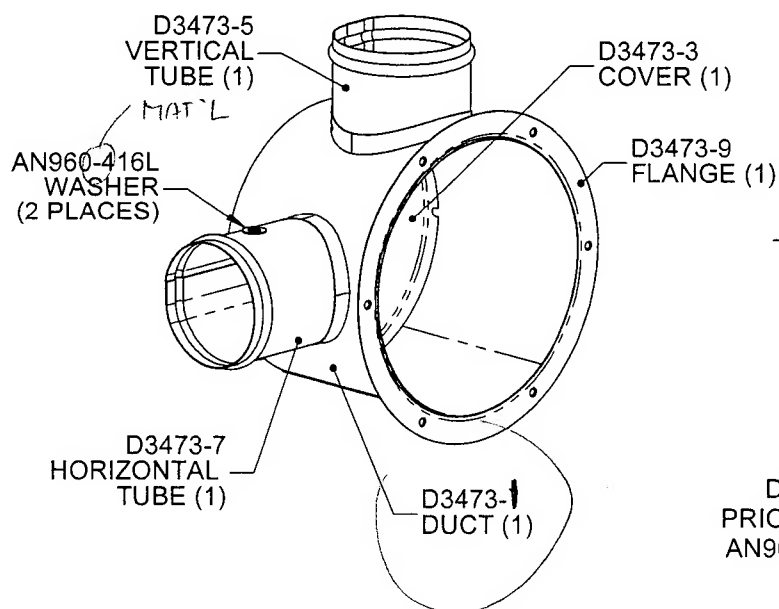
D3473-041 BLOWER INLET ADAPTER

NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010

PRELIMINARY ISSUE

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DATE 06.02.07		TITLE BLOWER INLET ADAPTER SCALE 1:4	



D3473-043 BLOWER INLET WELDMENT

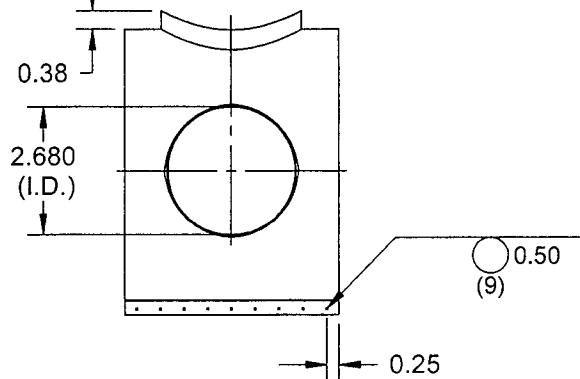
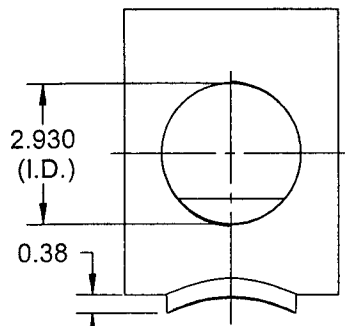
PARTS LIST

NOTES:

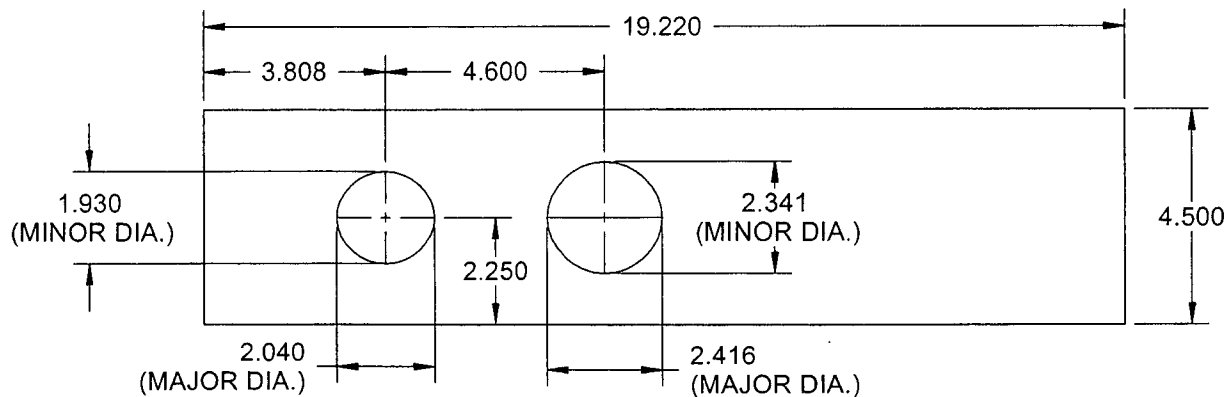
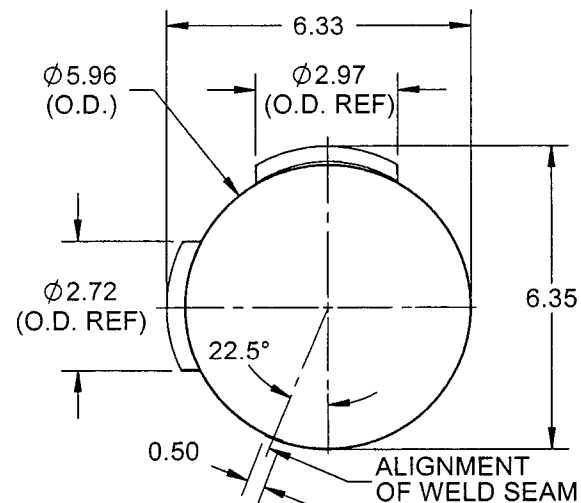
- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: ELECTRO-CHEMICALLY POLISH
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

PRELIMINARY ISSUE

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DATE 06.02.07		TITLE BLOWER INLET ADAPTER	SCALE 1:4



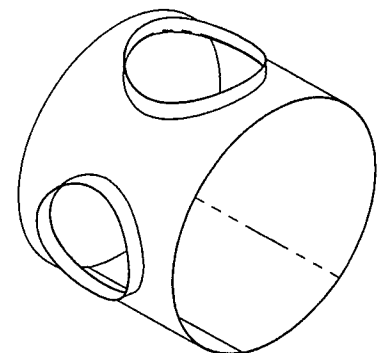
D3473-1 DUCT



D3473-1F DUCT FLAT PATTERN

NOTES:



- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED)
2B FINISH 26 GAUGE SS (0.018 THICK)
- 2) SPOT WELD PER DART QSI 004
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

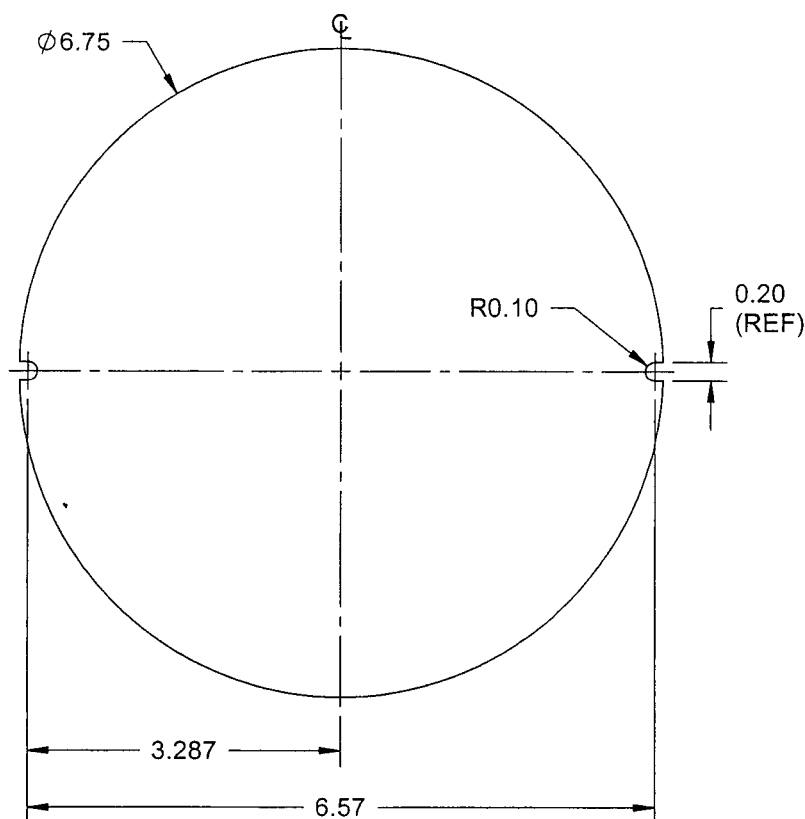


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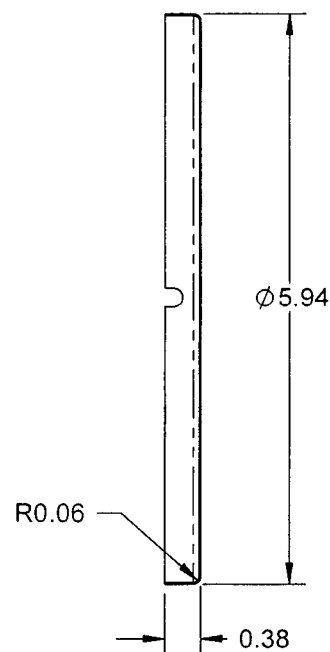
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DATE 06.02.07		TITLE BLOWER INLET ADAPTER	SCALE 1:2



D3473-3F COVER FLAT PATTERN



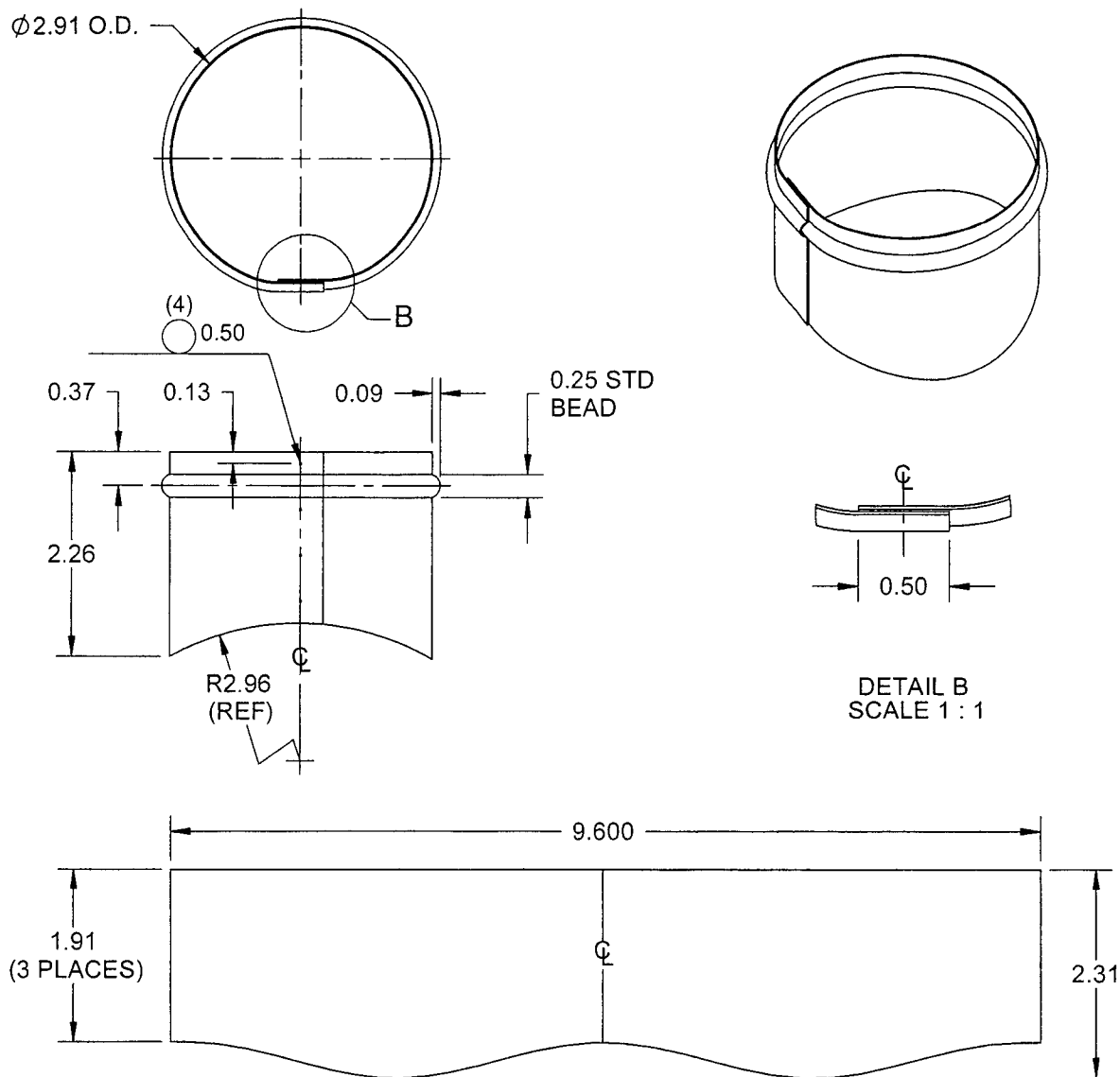
D3473-3 COVER

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DATE 06.02.07		TITLE BLOWER INLET ADAPTER	SCALE 1:2



D3473-5F VERTICAL TUBE FLAT PATTERN

NOTES:

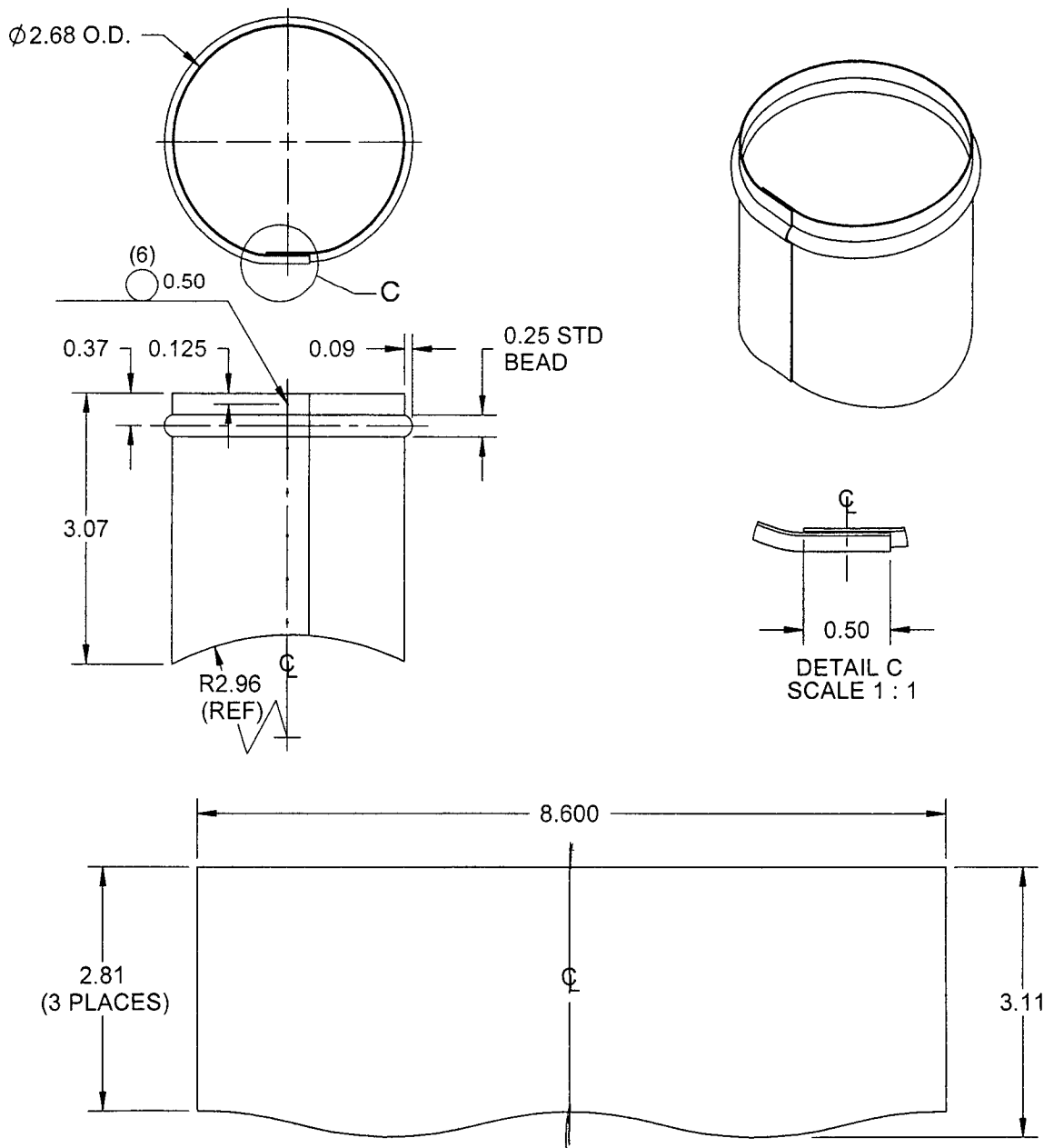
- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
- 2) SPOT WELD PER DART QSI 004
- 3) FINISH: NONE
- 4) FLAT PATTERN IS SYMMETRICAL ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DATE 06.02.07		TITLE BLOWER INLET ADAPTER	SCALE 1:2



D3473-7F HORIZONTAL TUBE FLAT PATTERN


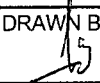


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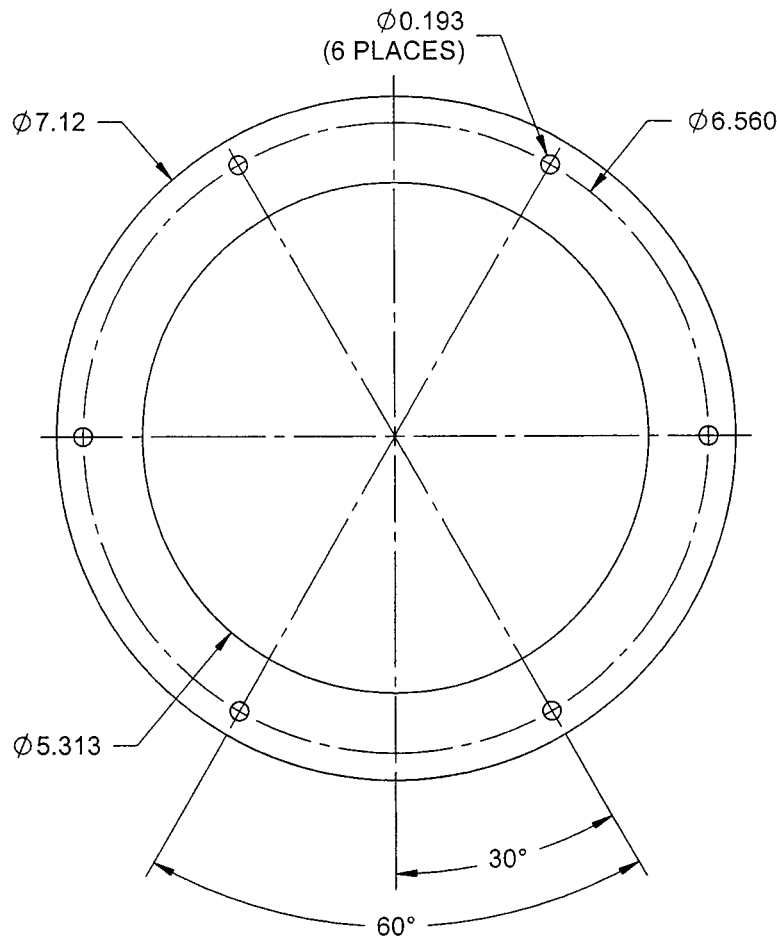
- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
- 2) SPOT WELD PER DART QSI 004
- 3) FINISH: NONE
- 4) FLAT PATTERN IS SYMMETRICAL ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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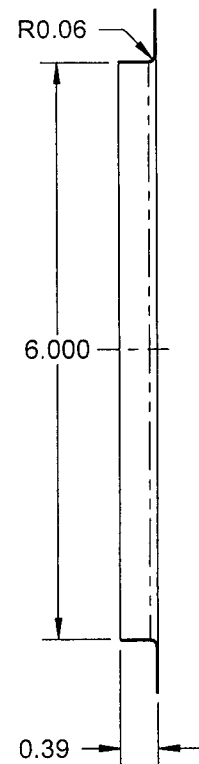
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DATE 06.02.07		TITLE BLOWER INLET ADAPTER	SCALE 1:2



D3473-9F FLANGE FLAT PATTERN



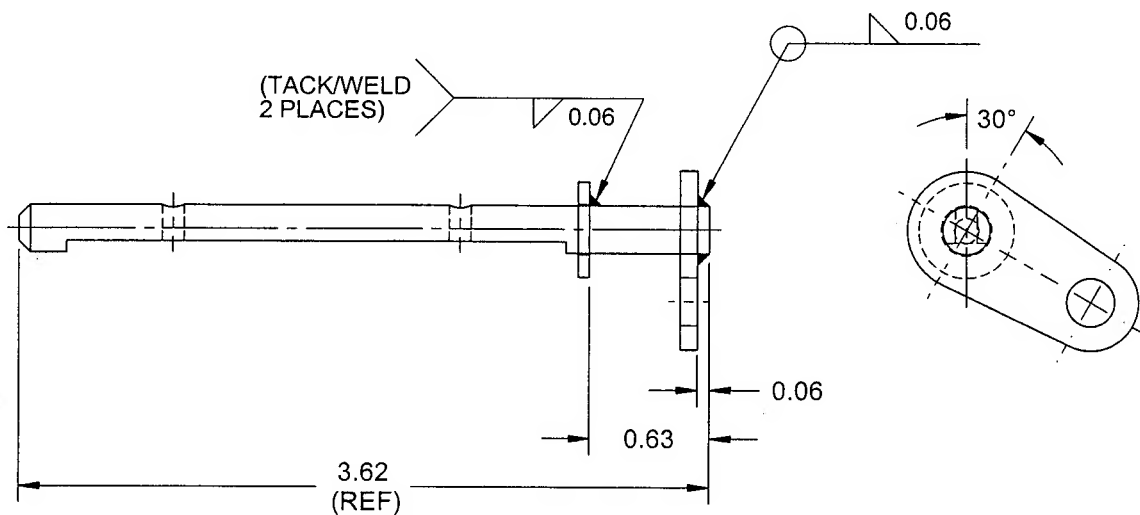
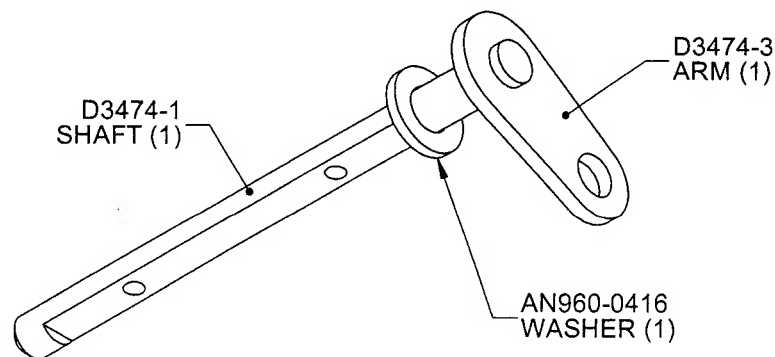
**D3473-9 FLANGE
BENDING DETAIL**

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

PRELIMINARY ISSUE

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DATE 06.01.23		TITLE INLET VALVE SHAFT	SCALE 1:1
A	06.01.23	NEW ISSUE	



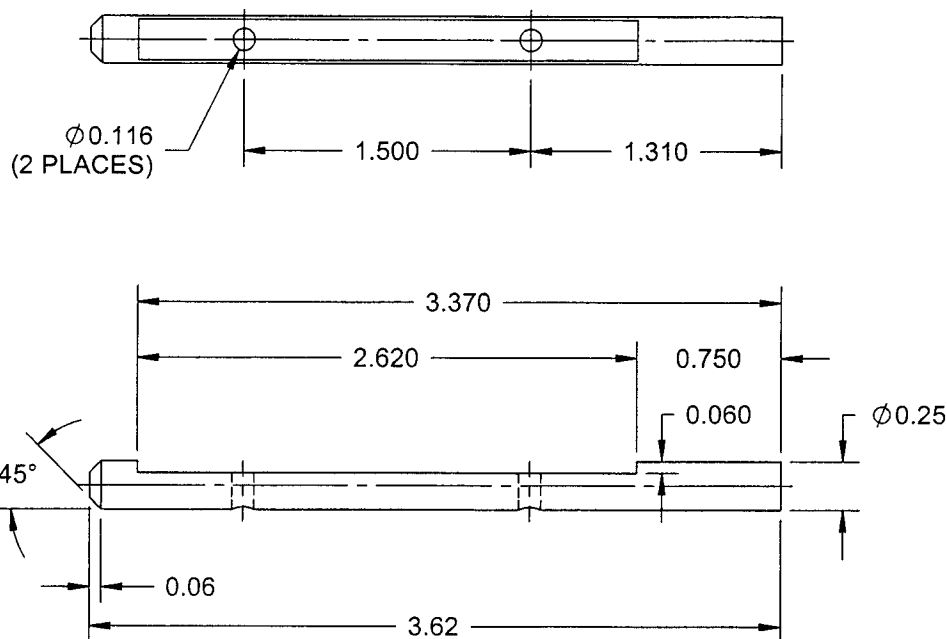
D3474-041 INLET VALVE SHAFT

NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: ELECTRO-CHEMICALLY POLISH
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

PRELIMINARY ISSUE

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CHECKED	APPROVED	DRAWING NO. D3474	REV. A SHEET 2 OF 4
DATE 06.01.23		TITLE INLET VALVE SHAFT	SCALE 1:1



D3474-1 SHAFT

NOTES:

- 1) MATERIAL: AISI 303 STAINLESS STEEL 0,25 ROUND BAR
(REF. DART SPEC. M303R0.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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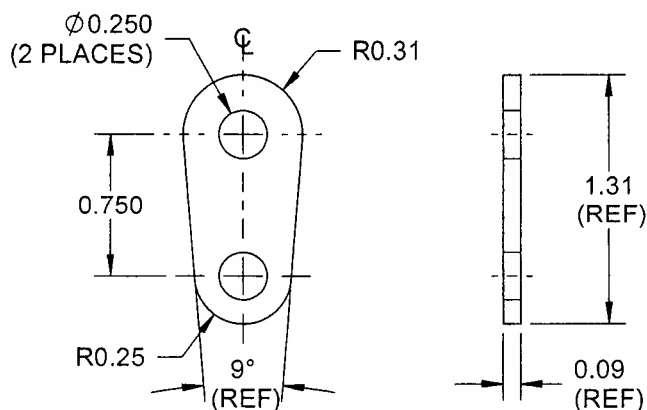
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CHECKED	APPROVED	DRAWING NO. D3474	REV. A SHEET 3 OF 4
DATE 03.01.23		TITLE INLET VALVE SHAFT	SCALE 1:1

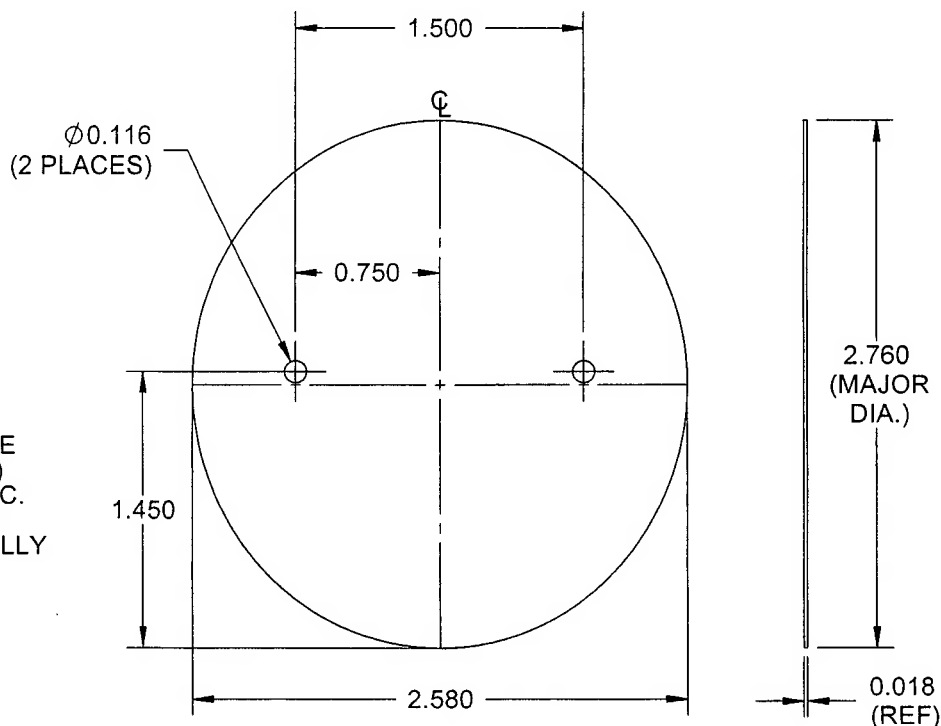
D3474-3 ARM FLAT PATTERN

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 13 GAUGE SS (0.090 THICK) (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE.



D3474-5 PLATE VALVE FLAT PATTERN



- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) FINISH: ELECTRO CHEMICALLY POLISHED.

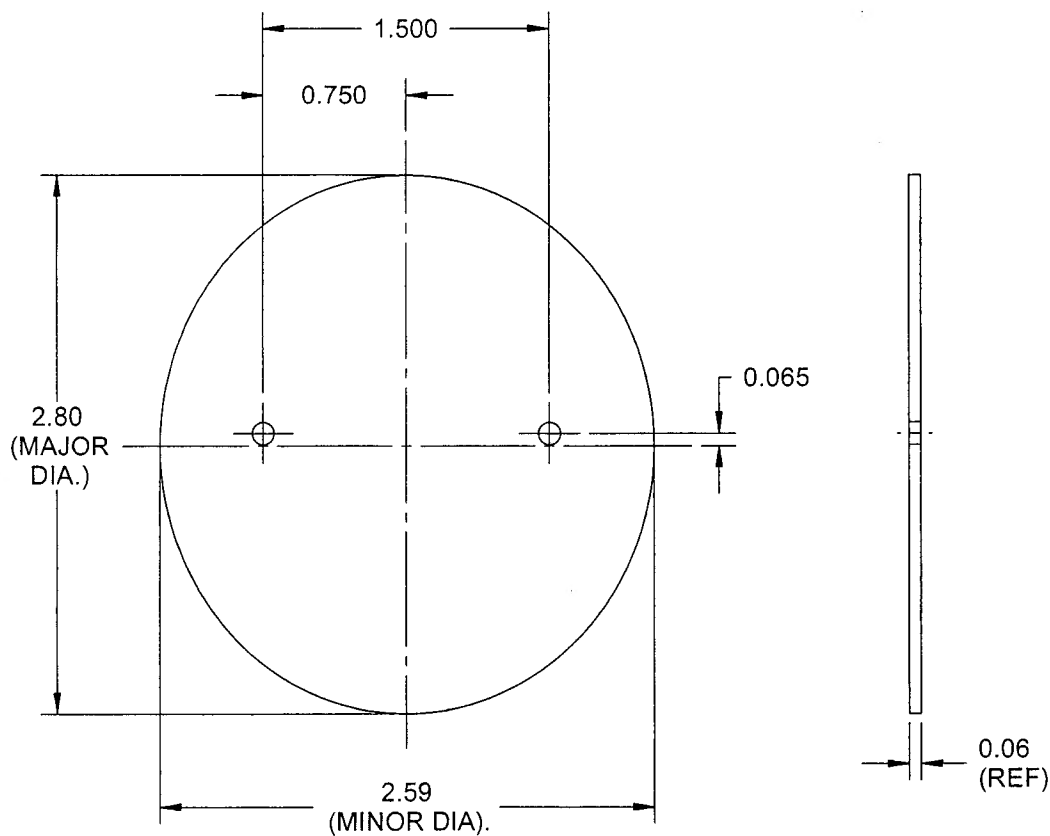


NOTES:

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

PRELIMINARY ISSUE

DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3474	REV. A SHEET 4 OF 4
DATE 06.01.23		TITLE INLET VALVE SHAFT	SCALE 1:1



D3474-7 VALVE SEAL

NOTES:

- 1) MATERIAL: RED (OR GRAY) 60 DUROMETER HI-TEMPERATURE SILICONE SHEET, 0.063 THICK (REF. DART SPEC. M-SIL60-S.063)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010